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(21) International Application Number: PCT/US97/18350 (22) International Filing Date: 6 October 1997 (06.10.97) (30) Priority Data: 08/733,285 17 October 1996 (17.10.96) US (71) Applicant: ISP INVESTMENTS INC. [US/US]; 818 Washington Street, Wilmington, DE 19801 (US). (72) Inventors: NARAYANAN, Kolazi, S.; 33 Carol Place, Wayne, NJ 07470 (US). IANNIELLO, Robert, M.; 5330 Berkshire Valley Road, Oak Ridge, NJ 07438 (US). (74) Agents: MAUE, Marilyn, J. et al.; International Specialty Products, Legal Dept., Building 10, 1361 Alps Road, Wayne, NJ 07470 (US).		(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GE, GH, HU, IL, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ZW, ARIPO patent (GH, KE, LS, MW, SD, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i>
(54) Title: A STABILIZED LIQUID EMULSIFIABLE CONCENTRATE FOR A SULFONYL OR SULFAMOYLUREA HERBICIDE (57) Abstract <p>A stabilized liquid emulsifiable concentrate for an active sulfonyl or sulfamoylurea herbicide is described. The liquid delivery system in the concentrate includes a polar solvent capable of dissolving the active herbicide, and which does not promote proton exchange between the active and solvent, suitably gamma-butyrolactone, propylene glycol, acetonitrile, or propylene carbonate; optionally with a hydrophobic solvent; and a mixture of anionic and non-ionic surfactants.</p>		

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A STABILIZED LIQUID EMULSIFIABLE CONCENTRATE
FOR A SULFONYL OR SULFAMOYLUREA HERBICIDE

BACKGROUND OF THE INVENTION

1. Field of the Invention

This invention relates to liquid delivery systems for active agricultural chemicals, and, more particularly, to a stabilized liquid emulsifiable concentrate for a sulfonyl or sulfamoylurea herbicide.

2. Description of the Prior Art

Sulfonyl or sulfamoylurea herbicides are very susceptible to hydrolysis in water or in admixture with other polar solvent which promote proton exchange between the active compound and the solvent. Accordingly, such compounds ordinarily are stored before application in the form of a solid delivery system only. However, it would be advantageous to provide a liquid delivery system for such compounds, preferably to provide a liquid emulsifiable concentrate which would be stable both during storage and when added to water to form a tank mix suitable for application to a plant site.

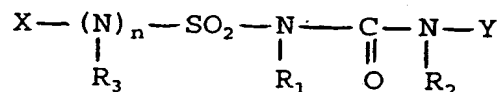
SUMMARY OF THE INVENTION

A stabilized liquid emulsifiable concentrate for a sulfonyl or sulfamoylurea herbicide is described herein, which is stabilized during storage for an extended period of time and usable upon dilution in water, comprises, by weight,

- (a) about 0.1-50% of one or more sulfonyl or sulfamoylurea herbicides, optionally,
- (b) in admixture with about 20-50% of one or more diluent agchemicals,
- (c) about 5-95% of a polar solvent selected from the group consisting of gamma-butyrolactone, acetonitrile, propylene glycol and propylene carbonate, and mixtures thereof, optionally,
- (d) about 1-90% of a hydrophobic solvent selected from the group consisting of vegetable oil, castor oil, petroleum distillates, esters of C₆-C₁₈ alkyl acetates, esters of C₁-C₄ carboxylic acid and C₆-C₁₈ alcohols, C₆-C₁₈ alkyl carbonates, C₆-C₁₈ diols, sterically hindered C₆-C₁₈ N-alkyl pyrrolidones and α -C₁-C₄ alkyl derivatives thereof, and limonene, and mixtures thereof, and
- (e) about 5-35% of a mixture of anionic and nonionic surfactants, and, optionally,
- (f) a buffering agent to provide a pH of about 4-8 upon addition of the concentrate to water in a dilution ratio of about 1:10.

DETAILED DESCRIPTION OF THE INVENTION

The active agricultural chemical in the present invention is a sulfonyl or sulfamoylurea having the general formula:



where X is a substituted aromatic/heterocyclic moiety or an electron withdrawing group e.g. a substituted sulfonamyl group;

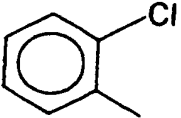
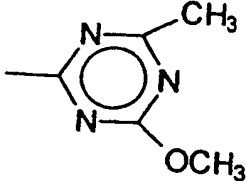
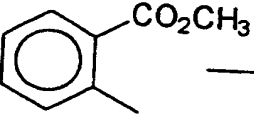
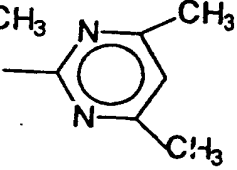
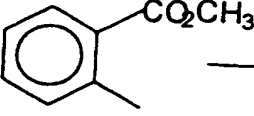
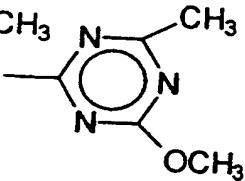
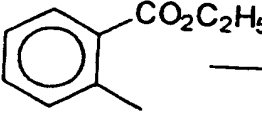
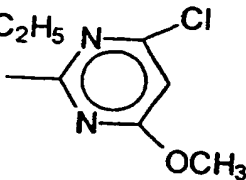
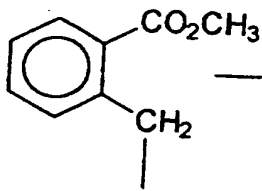
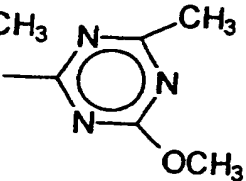
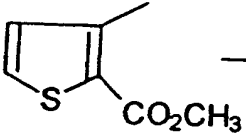
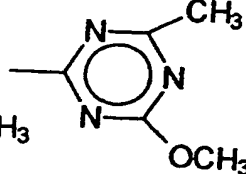
Y is a heterocyclic moiety;

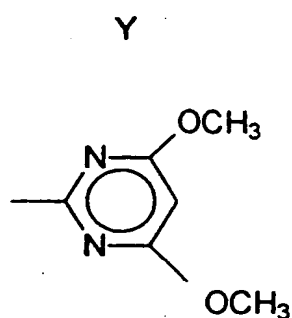
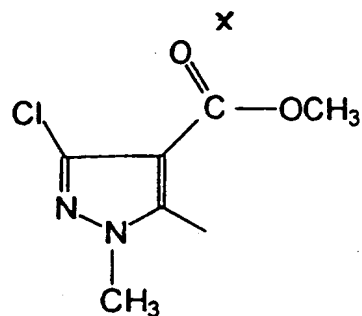
R₁/R₂/R₃ is hydrogen or a lower alkyl group.

Accordingly, when n = 0 the formula is a sulfonylurea, e.g. Metsulfuron® methyl (duPont); and when n = 1 the formula is a sulfamoylurea, e.g. Cyclosulfamuron® (American Cyanamid).

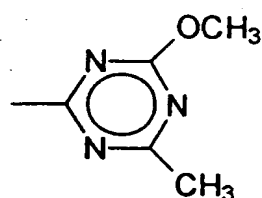
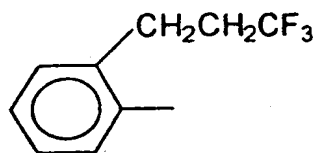
Both the sulfonyl and sulfamoylurea compounds have a labile sulfonamide bridge which is susceptible to hydrolysis in the presence of water or in admixture with another polar solvent. In this system, proton exchange is promoted between the solvent and the compound followed by reaction with water.

Typical active agricultural compounds solubilized herein are shown below:

X	Y	NAME	
		Chlorsulfuron	Du Pont
		Sulfometuron methyl	Du Pont
		Metsulfuron methyl	Du Pont
		Chlorimuron ethyl	Du Pont
		Bensulfuron methyl	Du Pont
		Thifensulfuron methyl	Du Pont

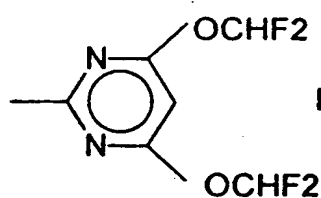
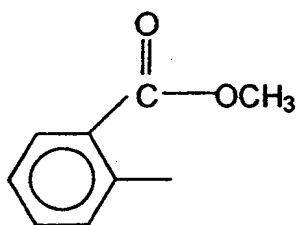


Halosulfuron methyl

Nissan/
Monsanto

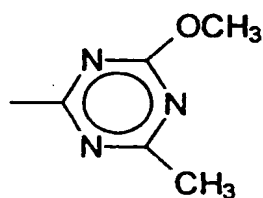
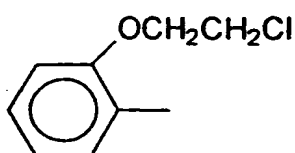
Prosulfuron

Ciba Geigy



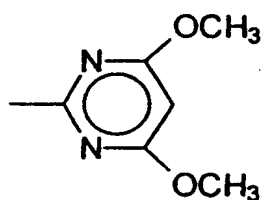
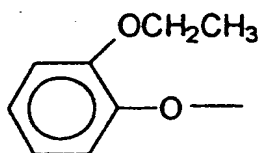
Primisulfuron methyl

Ciba Geigy



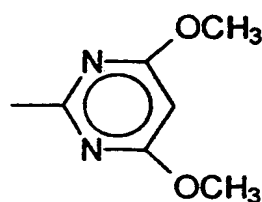
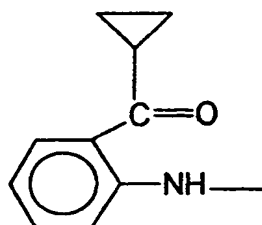
Triasulfuron

Ciba Geigy



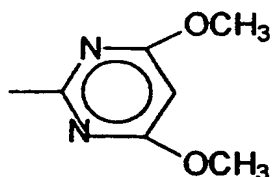
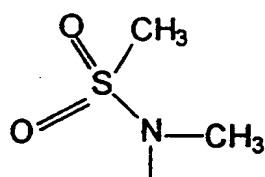
Ethoxysulfuron

Agrevo



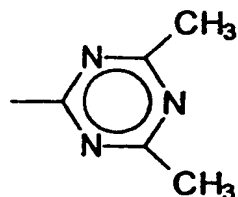
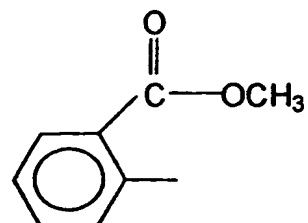
Cyclosulfamuron

Am Cy



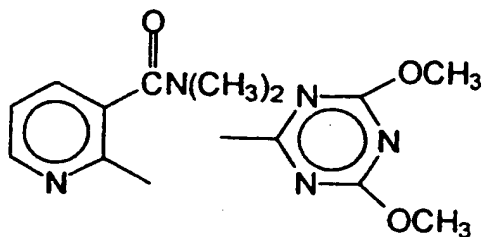
Amidosulfuron

Agrevo



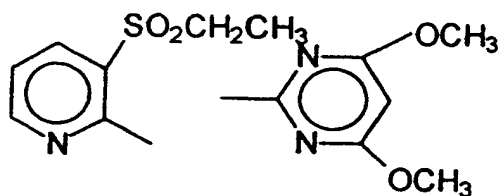
DPXL 5300

Du Pont



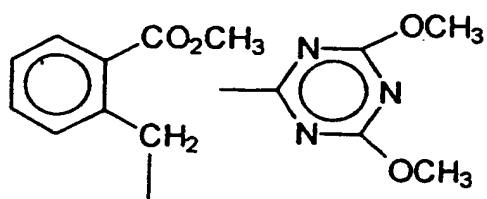
Nicosulfuron

Du Pont



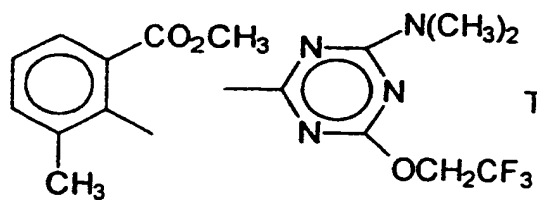
Rimsulfuron

Du Pont



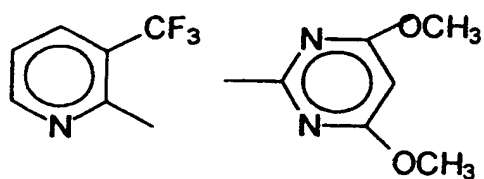
Londax

Du Pont



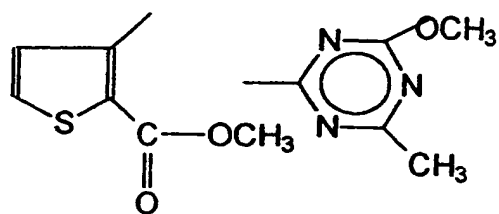
Triflusulfuronmethyl

Du Pont



Flazasulfuron

Ishihara



Trifensulfuron methyl

Du Pont

Sulfonylurea herbicides are effective at very low doses, i.e. at a rate of application of only grams per acre. However, it is important to avoid an overdose during use. For this reason, sulfonylureas generally are used in combination with a diluent agchemical in an amount of about 20-50% by weight of the concentrate. Such diluent agchemicals usually have broad spectrum activity at a dosage rate of lbs per acre. Another advantage of using diluent agchemicals in the concentrate is that while sulfonylureas are available commercially only as solids, the diluent agchemical can be obtained in liquid form, e.g. as an emulsifiable concentrate. Accordingly, their admixture will provide a diluted liquid premix of the active for transport and use in preparing the stabilized liquid emulsifiable concentrate of the invention.

Some examples of diluent agchemicals for use herein include:

(1) Phenoxy compounds:

e.g. phenoxy acetates (MCPA esters), phenoxy propionates, and phenoxy butyrates (MCPB esters);

(2) Benzoates (e.g. Dicamba);

(3) Chloroacetamide/chloroacetanilides (e.g. Alachlor, Acetachlor, and Metolachlor);

(4) Triazine derivatives (e.g. Metrubuzin), Triazinone (e.g. Metamitron);

(5) Carbanilates (e.g. Phenmedipham);

(6) Thiocarbamates (e.g. Thibencarb); and

(7) Phenylurea (e.g. Linuron and Diuron).

The liquid delivery system in the stabilized liquid emulsifiable concentrate of the invention includes a polar solvent, such as gamma-butyrolactone, propylene glycol or propylene carbonate, or mixtures thereof, preferably gamma-butyrolactone. These polar solvent compounds are capable of dissolving the sulfonylurea without catalyzing proton exchange between the solvent and active, which would result in an undesired hydrolysis in the presence of water. Suitably the polar solvent is present in the concentrate in an amount of about 5-95% by weight of the concentrate. Optionally, about 1-90% by weight of a hydrophobic solvent may be included in the solvent delivery system to enhance the advantageous characteristics of the stabilized concentrate.

The presence in these solvent components, in combination with a mixture of anionic and nonionic surfactants, provides an advantageous liquid delivery system for the agrochemicals. Such system provides a suitable emulsifiable concentrate for the active which will form a stable emulsion upon addition to water.

Optionally, a buffering agent may be included therein to provide a pH of about 4-8 upon addition of the concentrate to water in a dilution ratio of about 1:10.

The system of the invention also may be formed from a twin pack comprising, (a) a liquid solution of about 0.1-95% by weight of the active sulfonylurea

compound and about 5-99.9% by weight of the polar solvent, and (b) a mixture of anionic and non-ionic surfactants, and optional hydrophobic solvent, diluent agchemical and buffering agent. The twin pack may be admixed before use and then diluted with water to provide the desired liquid delivery system of the invention as a suitable tank mix.

Representative formulations of the invention are shown in Table 1. Related comparative formulations are presented as Comparative Examples D and E. Table 2 shows the stability data for these examples. The standard for a stabilized delivery system is considered a half-life, $t_{1/2}$, at ambient conditions, of at least 2 years. Invention Examples A through C, accordingly, demonstrate a half-life of 2-5 years, (estimated) whereas Comparative Examples D and E have a $t_{1/2}$ of only 8 months to 1 year.

TABLE 1

LIQUID EMULSIFIABLE CONCENTRATE

Components	<u>Invention Examples</u>			<u>Comparative Examples</u>		
	A	B	% wt. C	D	E	
<u>Agchemicals</u>						
<u>Active</u>						
Metsulfuron® methyl*- (duPont) a sulfonylurea	0.34	0.34	0.34	0.34	0.34	
<u>Diluent</u>						
MCPA Isooctyl ester- (isooctyl-2-methyl-4- chlorophenoxy acetate)	40	40	40	40	40	
<u>Polar Solvent</u>						
NMP - (N-methylpyrrolidone)	0	0	0	0	8.26	
BLO (gamma-butyrolactone)	9.96	9.96	35.0	25.0	0	
<u>Hydrophobic Solvent</u>						
NOP (N-octylpyrrolidone)	0	0	4.26	14.26	31.0	
EXXATE® 700 (mixed alkyl acetates) (EXXON)	0	28.9	0	0	0	

TABLE 1 (CONT'D)

LIQUID EMULSIFIABLE CONCENTRATE

Components	Invention Examples				Comparative Examples	
	A	B	C	D	E	F
Castor Oil	28.9	0	0	0	0	0
Surfactants						
Anionic						
Rhodofac® RM 710 (Rhone-Poulenc) (Dionylphenol-ethoxylated phosphoric acid)	4.0	4.0	2.0	2.0	2.0	2.0
Non-Ionic						
Alkamul EL® 719 (Rhone-Poulenc)	16.0	16.0	18.0	18.0	18.0	18.0
Castor Oil 40 EO						
Buffer						
TEA	0.80	0.8	0.4	0.4	0.4	0.4
Triethanolamine						
Total	100.0	100.0	100.0	100.0	100.0	100.0

TABLE 2

Stability Data

t _x (days) at 52°C.	5.8	2.9	3.0	1.0	0.8
t _x years, at ambient conditions (estimated)	5	2	2	1	0.7*

* HPLC analysis of sample stored under ambient conditions

TABLE 3
STABILITY OF METSULFURON® METHYL IN DIFFERENT SOLVENTS AT 52°C.

Time*, t (days)	Invention Examples		Non-Working Examples		
	Aceto- nitrile	Propylene Carbonate	N-Methyl- Pyrrolidone	N-Octyl Pyrrolidone	N-Tert- butyl Pyrrolidone
0	0.33	0.32	0.33	0.33	0.33
2	0.30	0.28	0.01	0.05	0.02
3	0.25	0.25	0.01	0.01	0.01
5	0.25	0.23	0.01	0.01	0.01

* Concentration of Active Present After Time t

Table 3 shows the extent of stability of solutions of active with individual polar solvents. Excellent stability was achieved when formulating the active with gamma-butyrolactone, acetonitrile or propylene carbonate, whereas the active decomposed rapidly in pyrrolidone solvents. Accordingly, the active may be stored in suitable polar solvents, e.g. gamma-butyrolactone, before admixture with the other ingredients of the emulsifiable concentrate.

While the invention has been described with particular reference to certain embodiments thereof, it will be understood that changes and modifications may be made which are within the skill of the art. Accordingly, it is intended to be bound only by the following claims, in which:

WHAT IS CLAIMED IS:

1. A liquid emulsifiable concentrate of an active agricultural chemical which is stabilized during storage for an extended period of time, and usable upon dilution in water, comprising, by weight,

(a) about 0.1-50% of one or more free sulfonyl or sulfamoylurea herbicides, which are ordinarily susceptible to hydrolysis in liquid formulations, optionally,

(b) in admixture with about 20-50% of one or more diluent agchemicals,

(c) about 5-95% of a polar solvent selected from the group consisting of gamma-butyrolactone, propylene glycol, propylene carbonate and acetonitrile, and mixtures thereof,

(d) optionally, about 1-90% of a hydrophobic solvent selected from the group consisting of vegetable oil, castor oil, petroleum distillates, esters of C₆-C₁₈ alkyl acetates, esters of C₁-C₄ carboxylic acid and C₆-C₁₈ alcohols, C₆-C₁₈ alkyl carbonates, C₆-C₁₈ diols, sterically hindered C₆-C₁₈ N-alkyl pyrrolidones and α -C₁-C₄ alkyl derivatives thereof, and limonene, and mixtures thereof,

(e) about 5-35% of a mixture of anionic and non-ionic surfactants, and,

(f) optionally, a buffering agent to provide a pH of about 4-8 upon addition to water in a dilution ratio of about 1:10.

2. A concentrate according to claim 1 wherein said active is a sulfonylurea.

3. A concentrate according to claim 1 wherein said active is a sulfamoylurea.

4. A concentrate according to claim 1 wherein said diluent agrochemical is present.

5. A concentrate according to claim 1 wherein the diluent agrochemical is a phenoxy acid ester or derivative thereof, a substituted benzoate ester or derivative thereof, a chloroacetamide or chloroacetanilide, a triazine, a carbanilate, a thio carbamate, or a phenylurea.

6. A concentrate according to claim 1 wherein said hydrophobic solvent is present.

7. A concentrate according to claim 1 wherein said buffering agent is present.

8. A concentrate according to claim 1 wherein said polar solvent is gamma-butyrolactone.

9. A stable emulsifiable agricultural liquid delivery solution comprising about 0.1-95% by wt. of a sulfonyl or sulfamoylurea herbicide and about 5-99.9% of a polar solvent selected from the group consisting of gamma-butyrolactone, acetonitrile, propylene carbonate and propylene glycol, and, optionally, 5-35% of a mixture of anionic and non-ionic surfactants.

10. A solution according to claim 9 wherein said solvent is gamma-butyrolactone.

11. A twin pack formulation comprising (a) the solution of claim 8, and (b) a composition comprising a mixture of anionic and non-ionic surfactants, optionally with (1) one or more diluent agchemicals, and/or (2) a hydrophobic solvent, and/or (3) water.

12. A twin pack according to claim 11 wherein a diluent agchemical is present.

13. A twin pack according to claim 12 wherein the hydrophobic solvent is present.

14. A twin pack according to claim 13 wherein water is present.

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US97/18350

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) :A01N 25/02, 25/30, 47/36

US CL :504/116, 211

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 504/116, 211

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

APS: sulf(ph)onyl/sulf(ph)amoyl-urea, nmp, acetonitrile, oils,

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
Y	US 4,515,620 A (BÖHNER) 07 May 1985, abstract, column 2, lines 52-66, columns 4-6.	1, 3-14
Y	US 5,518,991 A (FRISCH et al.) 21 May 1996, abstract, columns 1-3, column 4, lines 6-20, column 5.	1, 2, 4-14
Y	WO 91/03937 A1 (I.E. DU PONT DE NEMOURS AND COMPANY) 04 April 1991, pages 1-5, and 8.	1-14



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents:	*T* later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
A document defining the general state of the art which is not considered to be of particular relevance	*X* document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
E earlier document published on or after the international filing date	*Y* document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
L document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	*G* document member of the same patent family
O document referring to an oral disclosure, use, exhibition or other means	
P document published prior to the international filing date but later than the priority date claimed	

Date of the actual completion of the international search

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Date of mailing of the international search report

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Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer

S. Mark Clardy

Telephone No. (703) 308-1235

